



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-214
Job Sheet 170999



Part No: D350-591-214

Job Qty: 4 ea

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 1/29/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DS19294 JLM IPP Rev:C 06-06-27 Revised as per DS19340 JLM IPP Rev:D 10.11.15 update qty on AN4-11A DD ver:EC IPP REV:E 14.12.17 ADD DS19712-011 DD VERF:JLM IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/29/18	1/29/18	0.00	0.00	Start Up Stores/Pkg-2		FEB 08 2018 WY
270	Packaging	4 pcs	1/29/18	1/29/18	0.00	0.00	Packaging1-3		FEB 23 2018 SMD
280	QC	4 pcs	1/29/18	1/29/18	0.00	0.00	QC4		SMD
285	DC	4 pcs	1/29/18	1/29/18	0.00	0.00	DC		SMD
290	Packaging	4 pcs	1/29/18	1/29/18	0.00	0.00	Packaging3-1		SMD
300	QC21-FG	4 Ea	1/29/18	1/29/18	0.00	0.00	QC21		FEB 26 2018 DAS 21 98 Q39

Part Op **285** - Photocopy bluefile and type labels as per PPP D350-591-214 CHG005
Descriptions: **290** - Identify and pack for shipping as per PPP D350-591-214 Location:FG039

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	8 Ea (2 ea)	90-Start up Operation	
AN4-15A	Bolt	16 Ea (4 ea)	90-Start up Operation	
AN5-36A	Bolt	8 Ea (2 ea)	90-Start up Operation	
D2230-3	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	
D2618	Bushing	8 Ea (2 ea)	90-Start up Operation	
D2732-030	Rubber Cushion - 3"	16 Ea (4 ea)	90-Start up Operation	
D3235-1	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	
D3338-1	Mounting Lug	4 Ea (1 ea)	90-Start up Operation	
MS21042L3	Nut	8 Ea (2 ea)	90-Start up Operation	
MS21042L4	Nut	24 Ea (6 ea)	90-Start up Operation	
MS21042L5	Nut	8 Ea (2 ea)	90-Start up Operation	
NAS1149D0363J	Washer	16 Ea (4 ea)	90-Start up Operation	
NAS1149D0463J	Washer	48 Ea (12 ea)	90-Start up Operation	
NAS1149D0563J	Washer	16 Ea (4 ea)	90-Start up Operation	
D3078-042	Step Assembly, Hi Short RH	4 Ea (1 ea)	280-QC	

SD37016x4



Container No: S044901



Part: D350-591-214

Job No: 170999

Serial No/Batch: S044901

Revision: IIN-D350-591

Inspector:

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Date: 02/23/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	8	164	0
	AN4-15A	16	233	0
	AN5-36A	8	90	0
	D2230-3	8	133	0
	D2618	8	36	0
	D2732-030	16	344	0
	D3235-1	8	6	0
	D3338-1	4	41	0
	MS21042L3	8	3,785	0
	MS21042L4	24	1,849	0
	MS21042L5	8	497	0
	NAS1149D0363J	16	3,709	0
	NAS1149D0463J	48	3,164	0
	NAS1149D0563J	16	1,493	0
	D3078-042	4	4	0
280-QC				
Part Specifications				
Specifications could not be found.				



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Master Unit 000679

Tel (613) 632-5200

Containers on Master Unit 000679				
Serial No	Part No	Customer Part No	Status	Quantity
S040725	AN3-35A		Allocated	8
S040722	AN4-15A	AN4-15A	Allocated	16
S040720	AN5-36A	AN5-36A	Allocated	8
S040703	D2230-3	D2230-3	Allocated	8
S040700	D2618	D2618	Allocated	8
S040699	D2732-030	D2732-030	Allocated	16
S040696	D3338-1		Allocated	4
S040693	MS21042L3	MS21042L3	Allocated	8
S040692	MS21042L4	MS21042L4	Allocated	24
S040689	MS21042L5	MS21042L5	Allocated	8
S040687	NAS1149D0363J	NAS1149D0363J	Allocated	16
S040684	NAS1149D0463J	NAS1149D0463J	Allocated	48
S040682	NAS1149D0563J	NAS1149D0563J	Allocated	16

D3335-1 504895 X8

D3078-042 5037016 X4

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

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Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

[illegible]

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								